

Abstract

Tuesday, September 22, 2009 3:09:23 PM

Accept

**Setup Start**[illegible]

Stop

**Cust Item ID:**

11/11/2001 11:11:11 AM

Customer:

Run Start



Stop

[illegible]

**Insp.
Stamp**

0.00

[illegible]

NC BRAKE

0.00

Brake NC

Memo

Brake NC

Deburr□Form using DT8204 as per Dwg D3405

88 09/10/19

15



0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

2) 809/10/17

15

6

0.00

1 11111111 11111111 11111111 11111111 11111111

Large Fab

0.00

Large Fab

Memo

Large Fab

Weld as per Dwg D3405□Identify as D3405-041

Q 9-10-20

x/5

Work Order ID 52323

Tuesday, September 22, 2009 3:09:23 PM



Page 3

Item ID:	D3405-041	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Lug Assembly					
Start Date:	9/23/2009	Start Qty:	12.00		Cust Item ID:	
Required Date:	10/9/2009	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<i>PL</i>	<i>09</i>	<i>10</i>	<i>20</i>
170 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>=> Serial 121</i>		<i>(X15)</i>	<i>/</i>		
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3- ² Alum ^{Steel} Memo START TIME: <i>10:45AM</i> OVEN TEMPERATURE: <i>11:15AM</i> FINISH TIME: <i>4009F</i>	0.00 0.00		<i>=> 1112260</i>		<i>(X15)</i>	<i>0</i>		

Work Order ID 52323

Tuesday, September 22, 2009 3:09:23 PM



Page 4

Item ID: D3405-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

BR 09-10-20

15



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 474

0.00



Packaging

Memo

0.00

Packaging

9/10/23 150 sf

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

H. 09-10-27
MF
09-10-24

Picklist Print

Page 1

Tuesday, September 22, 2009 3:09:22 PM

Work Order ID: 52323



Parent Item: D3405-041RevB



Parent Item Name: Lug Assembly

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3404-1RevC 		Manufactured	No			100	Each	63.0000	12.0000			
GHW Lug												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

~~52314~~

50471

51548

52575 x 7

63

8

25

30

7

8

2.4316

18 9-10-03

M304S11GA



304/316 0.125 Sheet

Purchased

No

150

sf

132.3156

1.9453

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111018

112663

132.3155979

4.31559789

128

111018

SHOP COPY

RETURN TO:

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

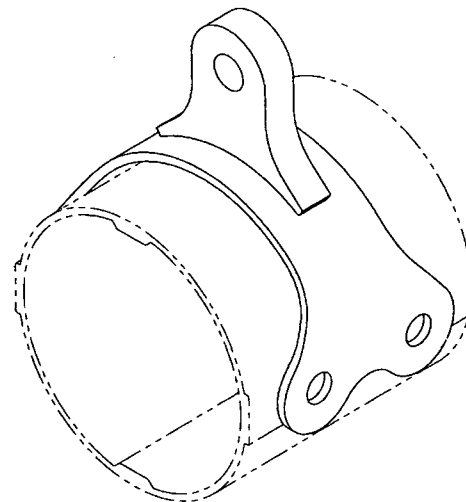
WORK ORDER

NO. 52323

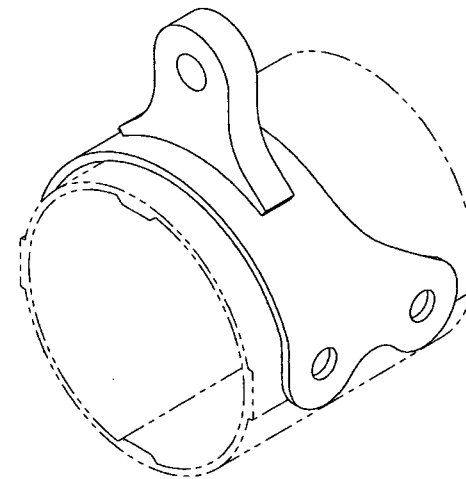
RELEASED
08/12/18 MP

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



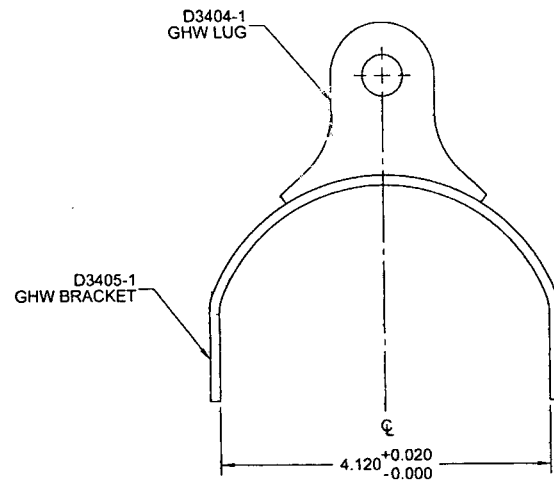
D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

NOTES:

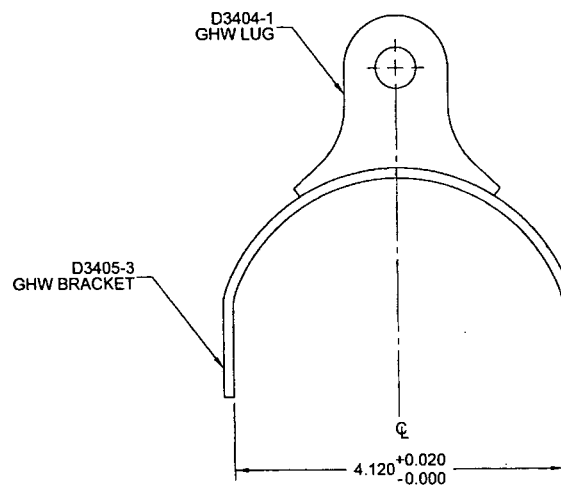
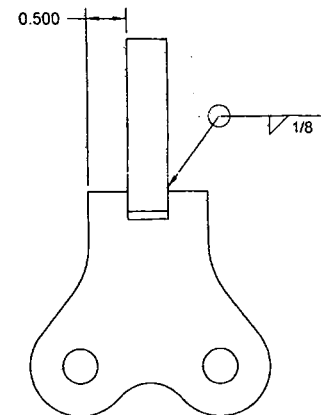
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

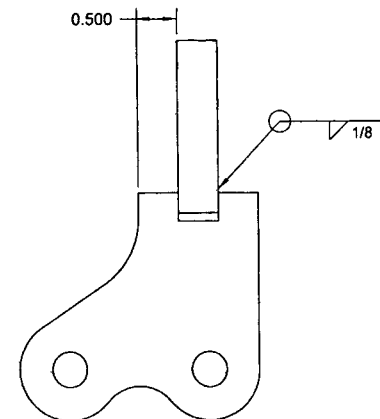
52323



D3405-041 LUG ASSEMBLY



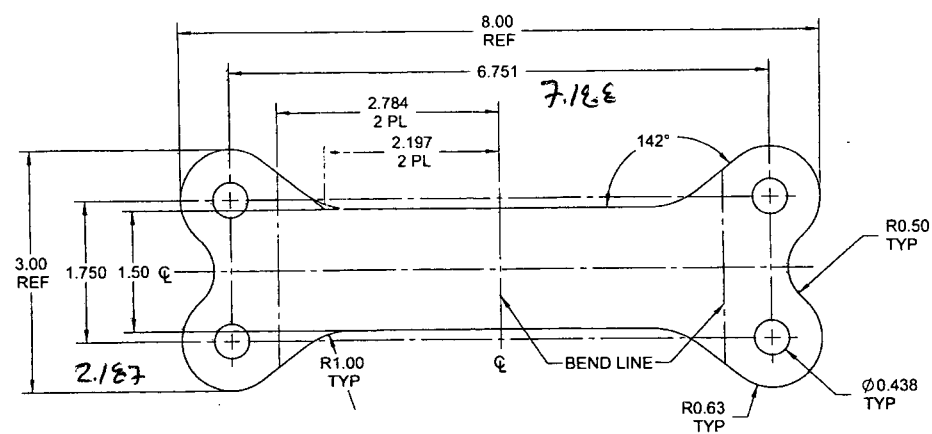
D3405-043 LUG ASSEMBLY



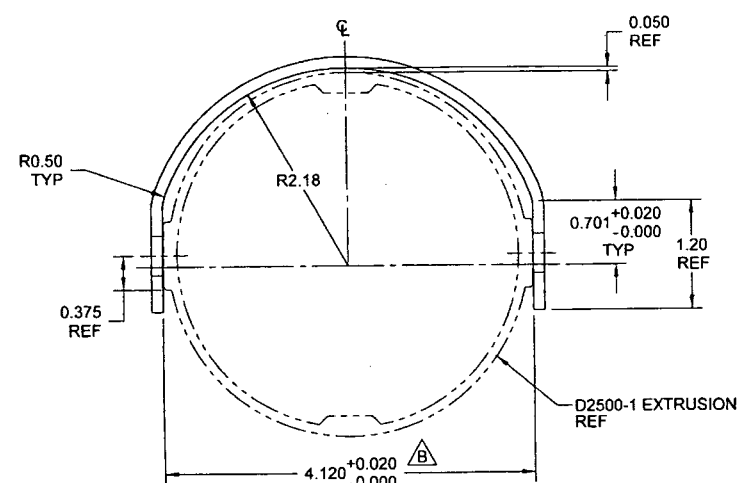
RELEASED
6/12/18

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

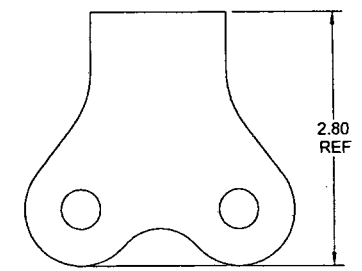
52323



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



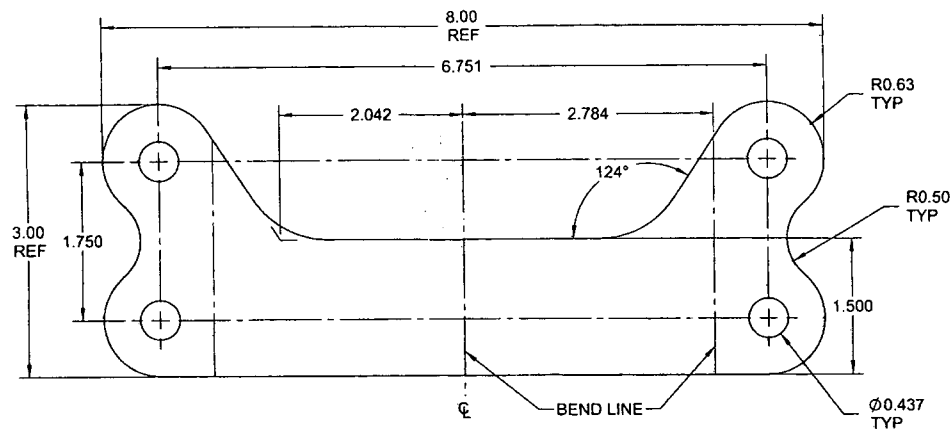
SIDE VIEW FOR REF ONLY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

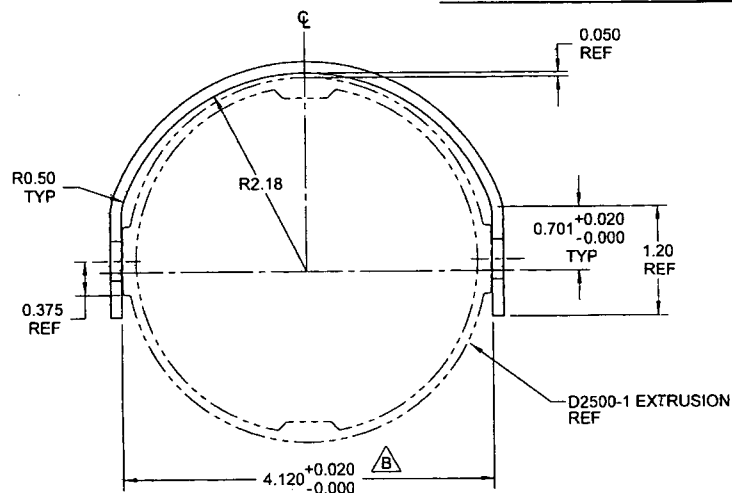
RELEASED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

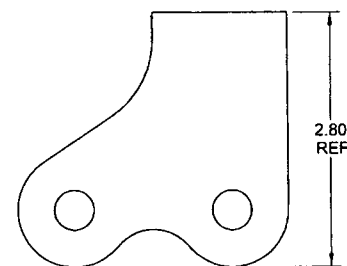
52323



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

RELEASED
08/12/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE GHW LUG ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.19		

